

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72138

Tuesday, July 19, 2011 12:45:02 PM



Page 2

Item ID: D2806-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 7/19/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20 X Ø M-11/08/2011

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/8/30 SD

150

Identify as per dwg & Stock Location: ST 22

0.00



Packaging

Memo

0.00

Packaging

20 X Ø M-11-08-30

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Accept



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Stop



Item Name: Bushing

Start Date: 7/19/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/30
MF
11-08-30

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Picklist Print

Tuesday, July 19, 2011 12:45:08 PM

Page 1

Work Order ID: 72138



Parent Item: D2806-3



Parent Item Name: Bushing

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐ B ☐ 05.03.11 ☐ Part now turned ☐ KJ/JLM
IPP Rev:C Now on Doosan Lathe JLM Verified By:EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6H1.000 		Purchased	No			110	f	10.9180	0.0916	1.928421		11/18/25	

6061-T6 HexBar 1.00

Location

MAT012

109478

116623

Loc Qty

10.918

1.721

9.197

Loc Code

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DART AEROSPACE LTD		Work Order: 72138
Description: Bushing		Part Number: D2806-3
Inspection Dwg: D2806	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.005	/		SA-7	
1.155	+/-0.010	1.145	/			
0.250	+/-0.010	0.250	/			
0.063 x 45°	+/-0.010	0.063 x 45°	/			
0.080 x 45°	+/-0.010	0.080 x 45°	/			
0.495	+0.000/-0.005	0.493	/			
0.750	+0.000/-0.005	0.749	/			
Ø0.316	+0.005/-0.000	Ø0.317	/			
0.094	+/-0.005	0.094	/			

Measured by: SA	Audited by: and	Prototype Approval:	N/A
Date: 11/8/25	Date: 11/08/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	08.11.27	0.094 dimension added	KJ/EC	

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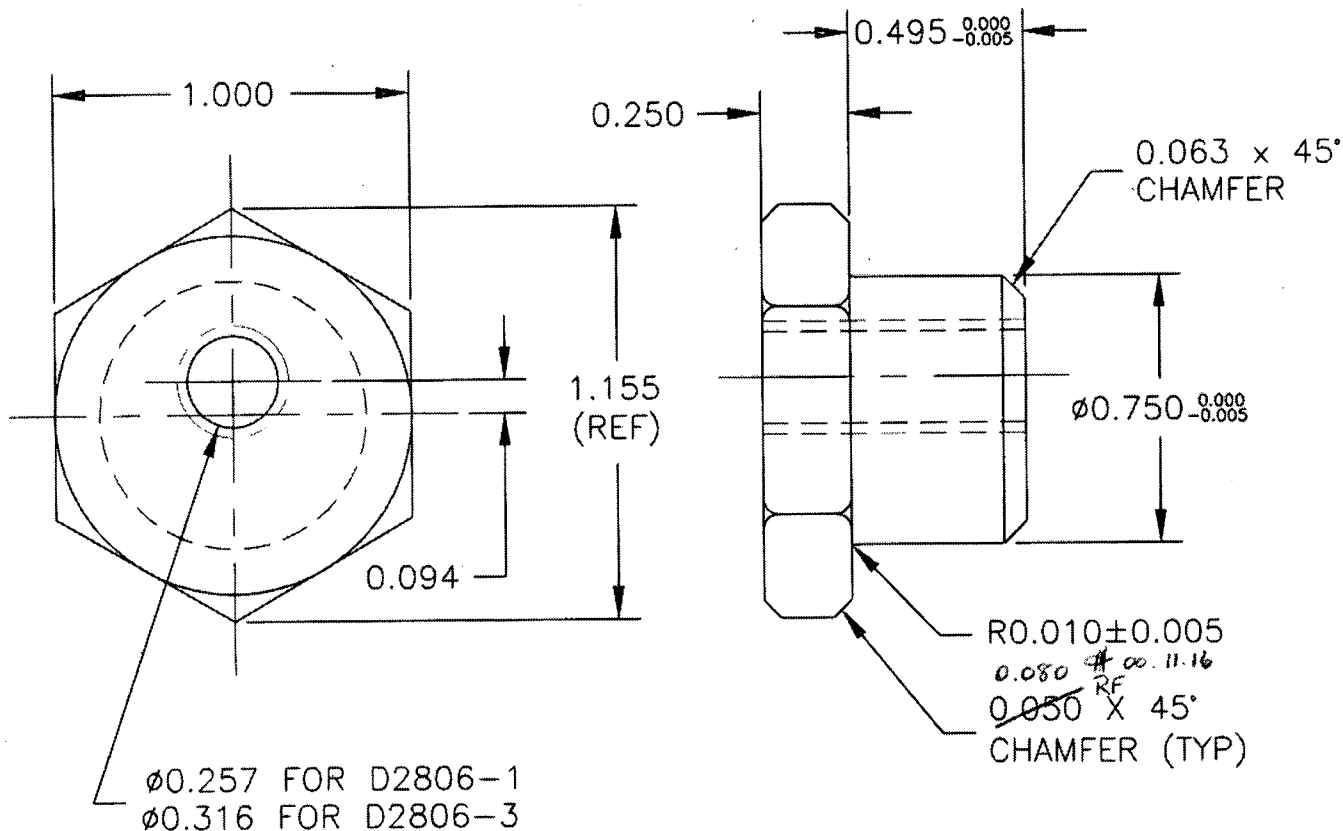
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 *[Signature]*



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72138

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

11-07-19

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